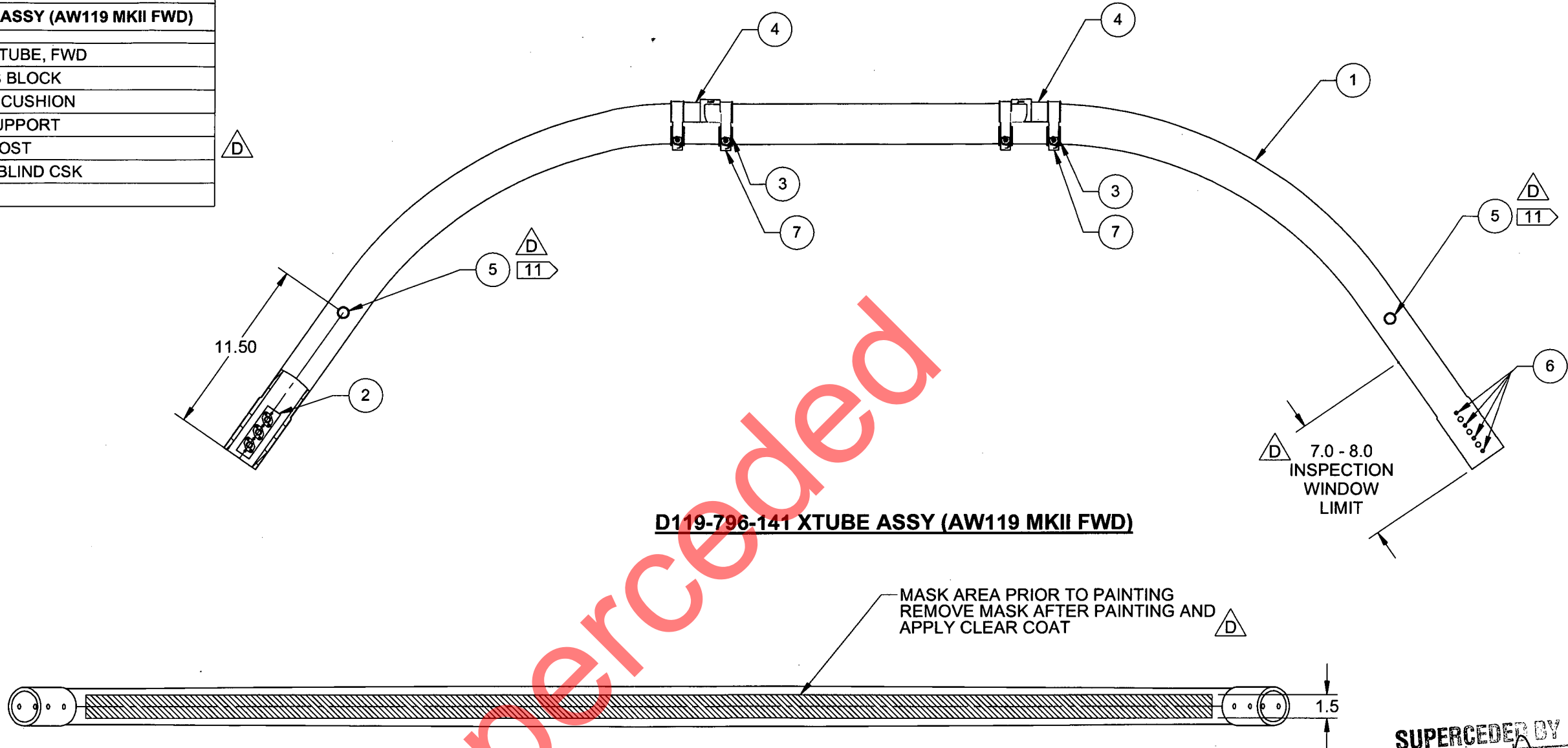


ITEM	QTY -141	P/N	DESCRIPTION
	X	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141BND	CROSSTUBE, FWD
2	4	D2873-043	RADIUS BLOCK
3	4	D5123-3	CLAMP CUSHION
4	2	D5124-1	FWD SUPPORT
5	2	D5150-1	STEP POST
6	16	CR3212-4-07	RIVET, BLIND CSK
7	4	MS21920-24	CLAMP



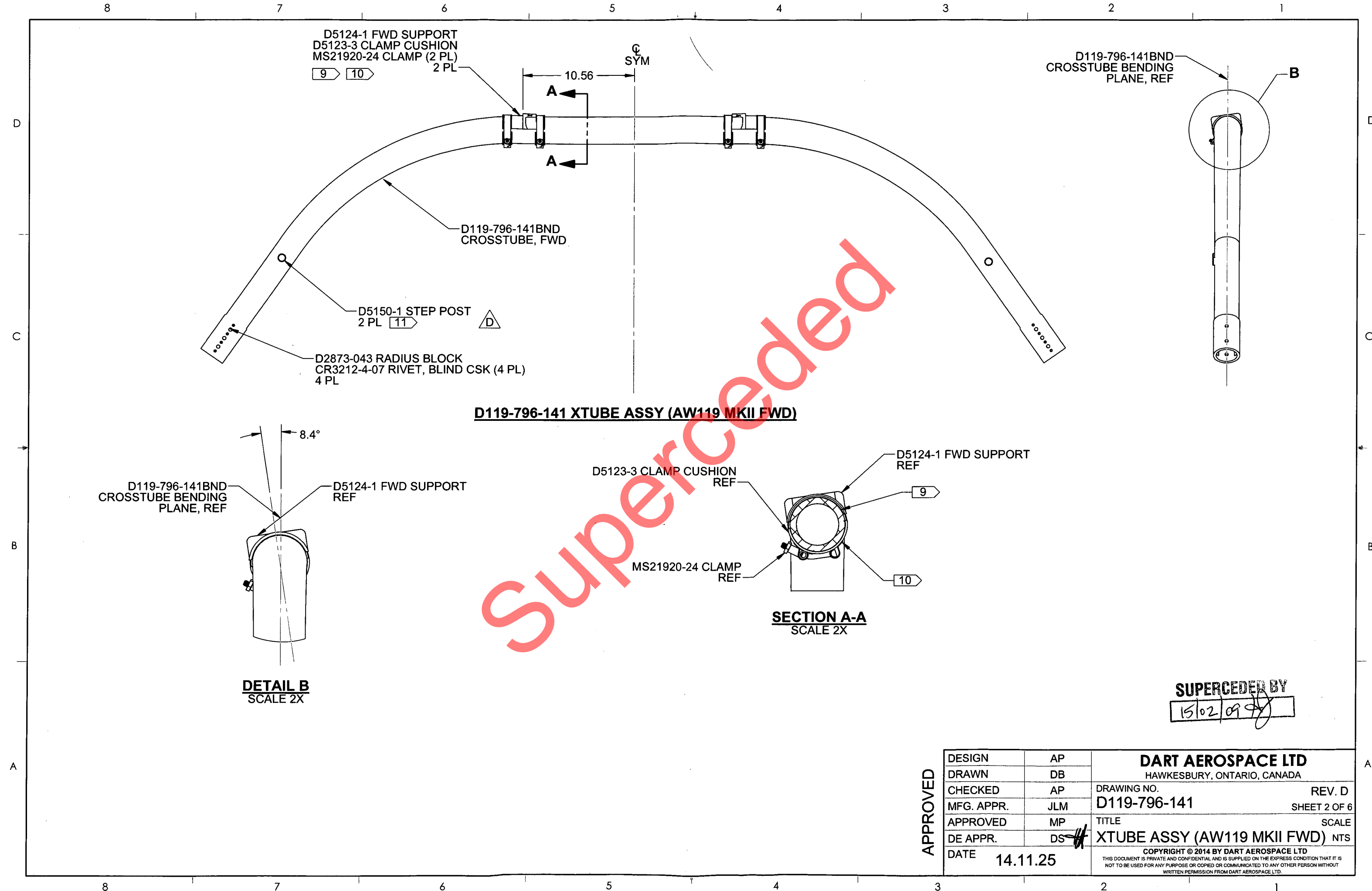
D119-796-141 XTUBE ASSY (AW119 MKII FWD)

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NOTES:

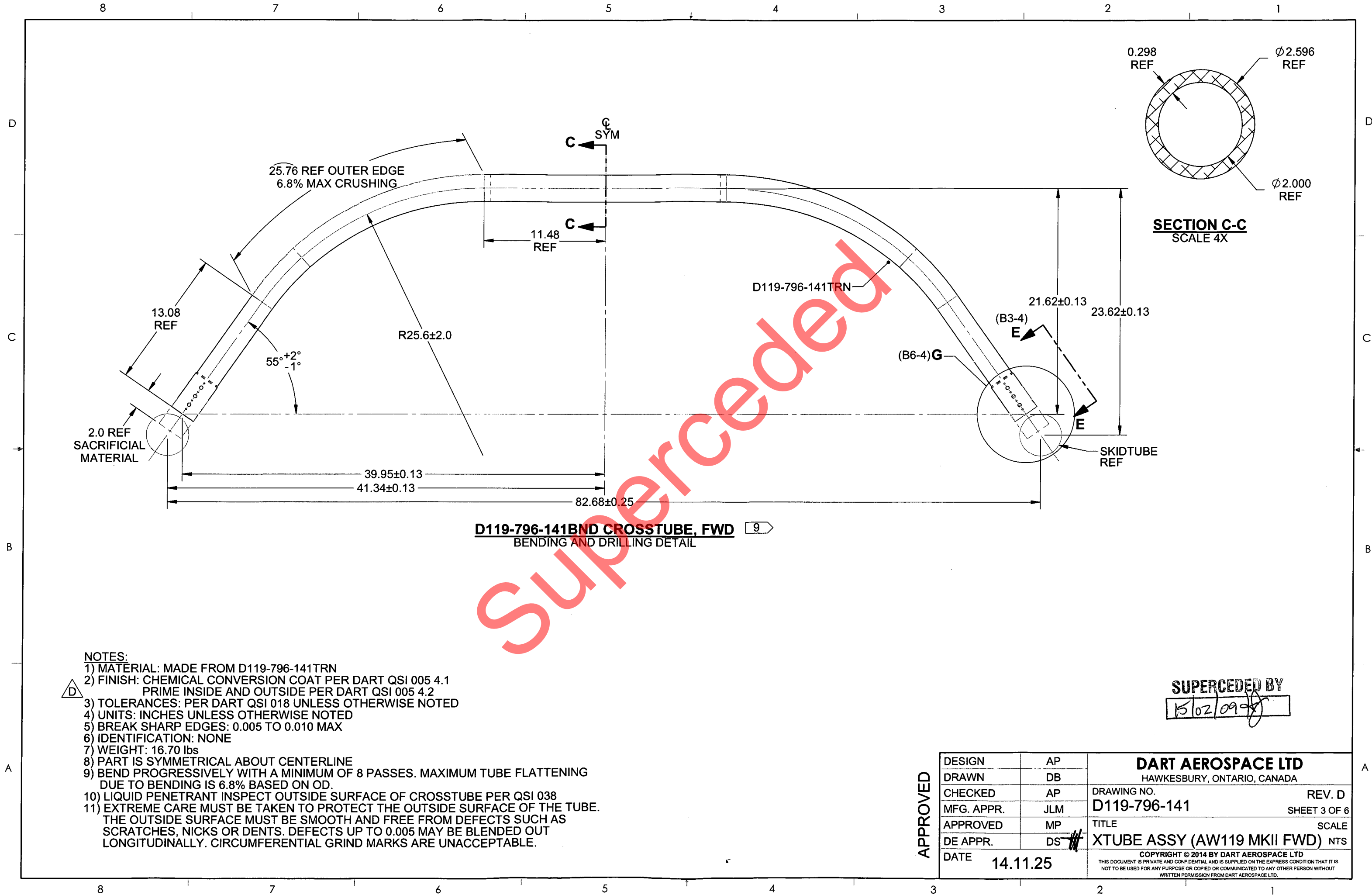
- 1) MATERIAL: N/A
- 2) FINISH: MASK UNDERSIDE OF CROSSTUBE AS SHOWN (B3-1, HATCHED AREA), PAINT OUTSIDE PER DART QSI 005 4.2 REMOVE MASKING AND APPLY MATTE CLEAR COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY USING PART NUMBER "D119-796-141" AND BATCH NUMBER ON INSIDE OF CUFF PER QSI 044 6.4
- 7) WEIGHT: 17.98 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) AFTER FINISHING, ABRASE MATING SURFACES OF D5124-1 FWD SUPPORTS AND CROSSTUBE WITH 180 GRIT SANDPAPER AND REMOVE RESIDUE WITH DUPONT 4105S WASH'N'WIPE DEGREASER. APPLY A 0.100 MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5124-1 FWD SUPPORTS AND INSTALL AT AN 8.4° OFFSET FROM THE CROSSTUBE BENDING PLANE. INSTALL THE MS21920-24 CLAMPS AND D5123-3 CLAMP CUSHIONS WHILE WET.
- 10) TORQUE MS21920 CLAMPS 80 - 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY, THE NUT IS FACING AFT AND HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 11) PRIOR TO FINISHING, ABRASE MATING SURFACES OF CROSSTUBE WITH 180 GRIT SANDPAPER AND REMOVE RESIDUE WITH DUPONT 4105S WASH'N'WIPE DEGREASER. INSTALL D5150-1 WITH LAYER OF PROSEAL 890 ON INSIDE CONCAVE SURFACE, 0.100 MIN THK. LOCATE D5150-1 USING TOOL DT10089.

D	ADD D5150-1 STEP POST (2X), MOVED INSPECTION WINDOW DETAIL TO SHEET 1, MODIFIED NOTES ON SHT 1 & 3	DB	14.11.25
C	CR3212-4-07 RIVETS WERE CR3212-4-09, 7.5 DEG CUFF ANGLE OFFSET REMOVED (SHT 3), CUFF DIAMETER ON D119-796-141TRN REDUCED TO 2.500, ADDED INSPECTION WINDOW (B7-3), ADDED SHT 4	AP	14.10.23
B	ADDED D2873-043 RADIUS BLOCK, CR3212-4-09 RIVETS, ADDED SKIDTUBE REFERENCE FOR LOCATING CUFF HOLES. RO-ORGANIZED NOTES AND REMOVED REDUNDANT INFORMATION	AP	14.09.02
A	NEW ISSUE	AP	14.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D119-796-141	SHEET 1 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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MFG. APPR.	JLM		SHEET 2 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>XTUBE ASSY (AW119 MKII FWD)</b>	NTS
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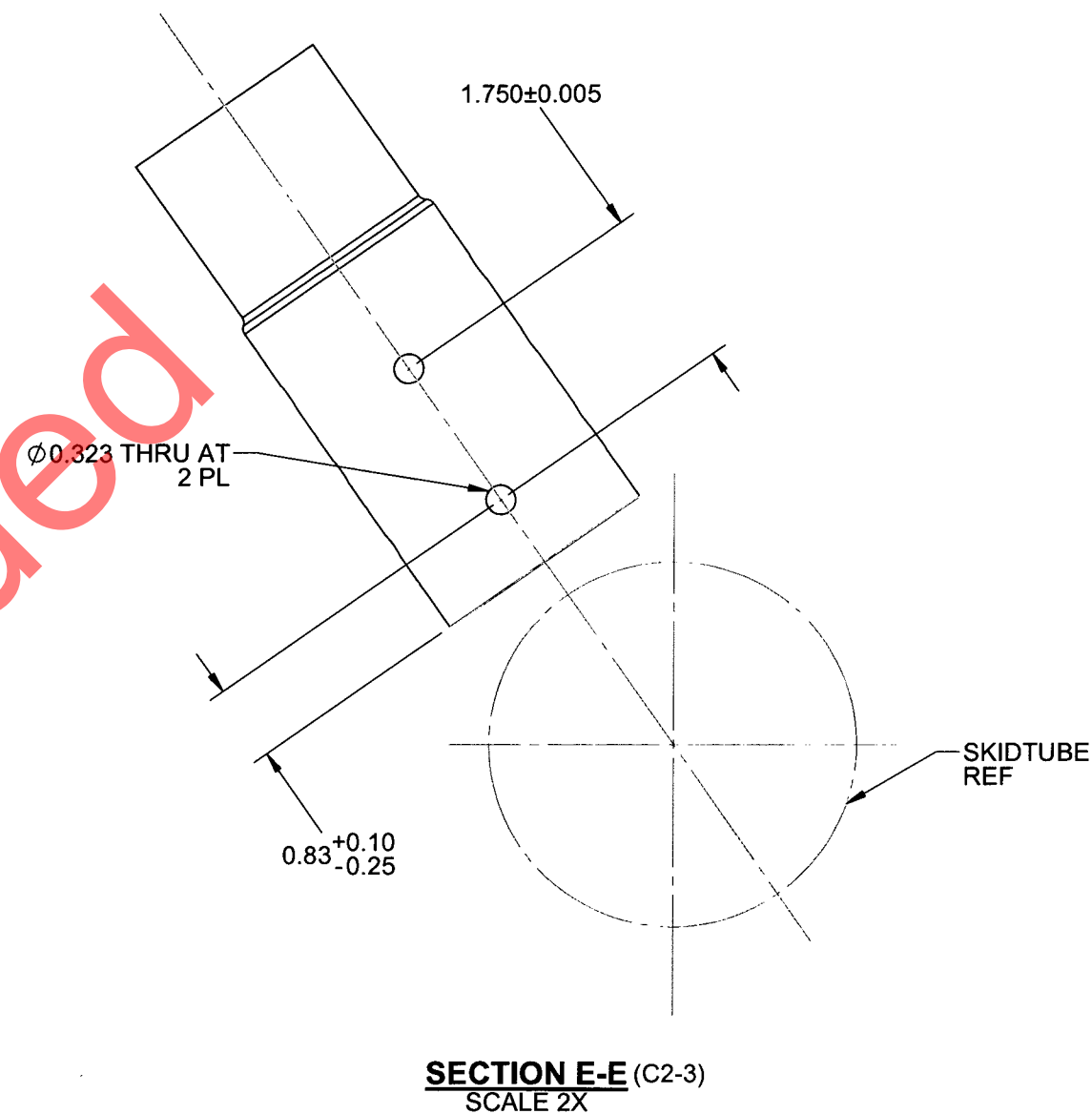
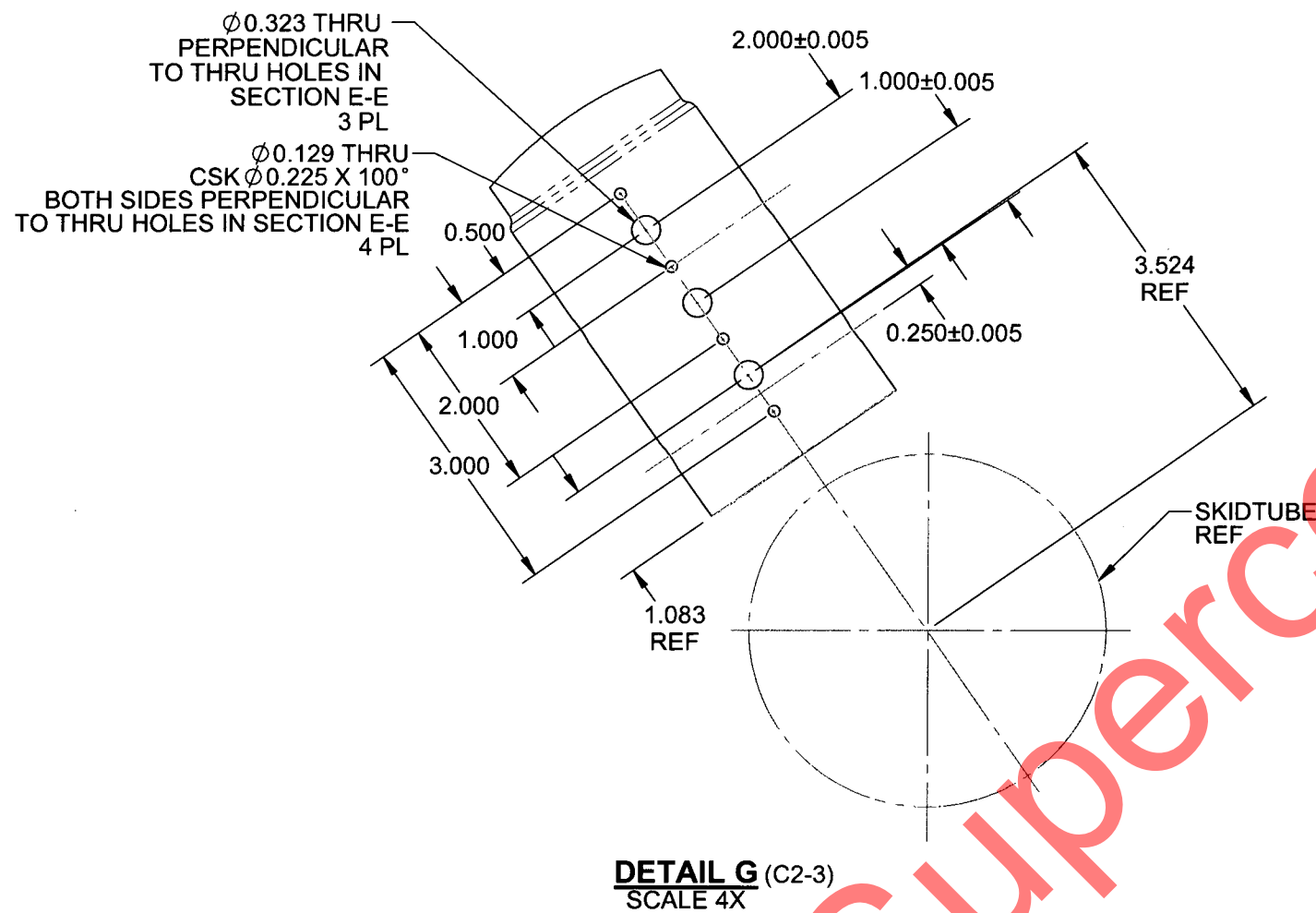
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4

3

2

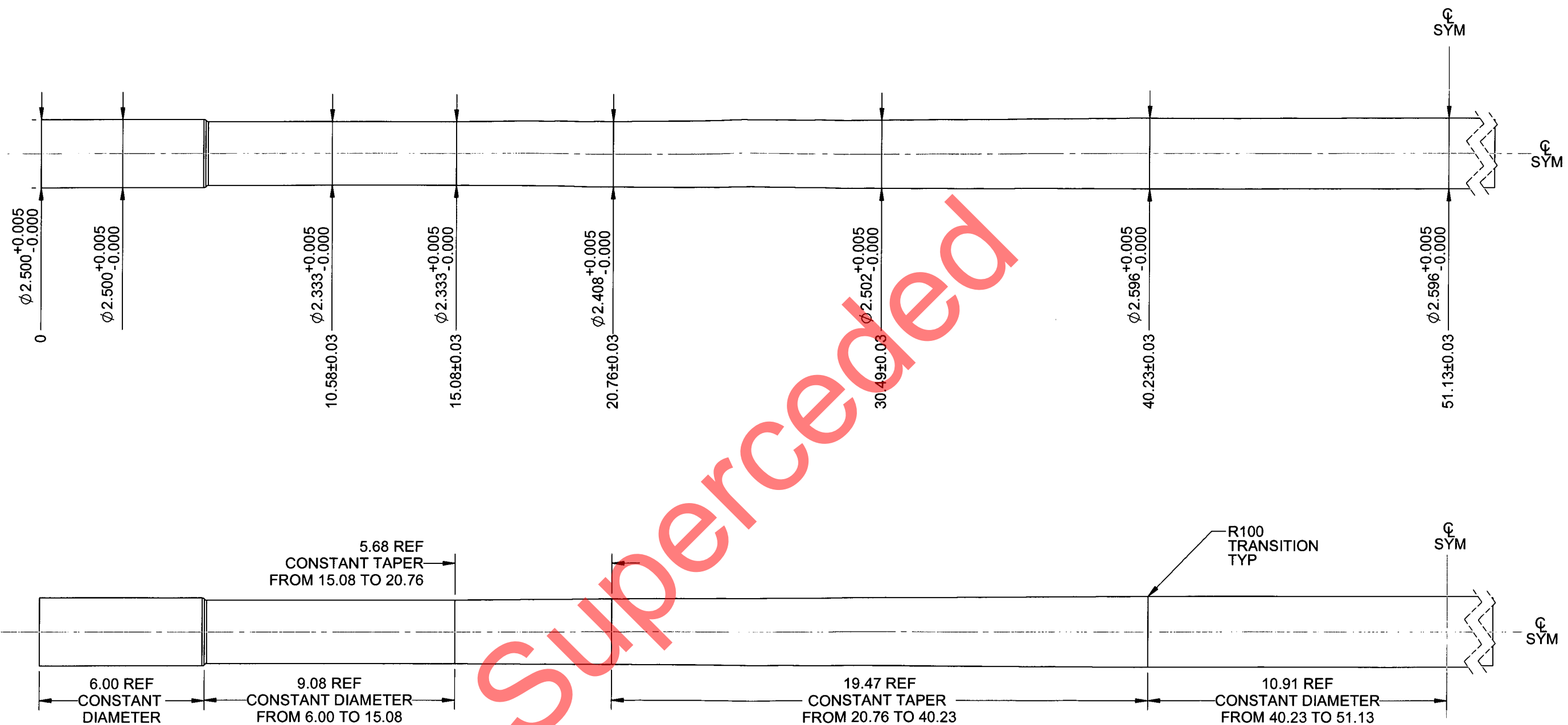
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MFG. APPR.	JLM		SHEET 4 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>XTUBE ASSY (AW119 MKII FWD)</b>	NTS
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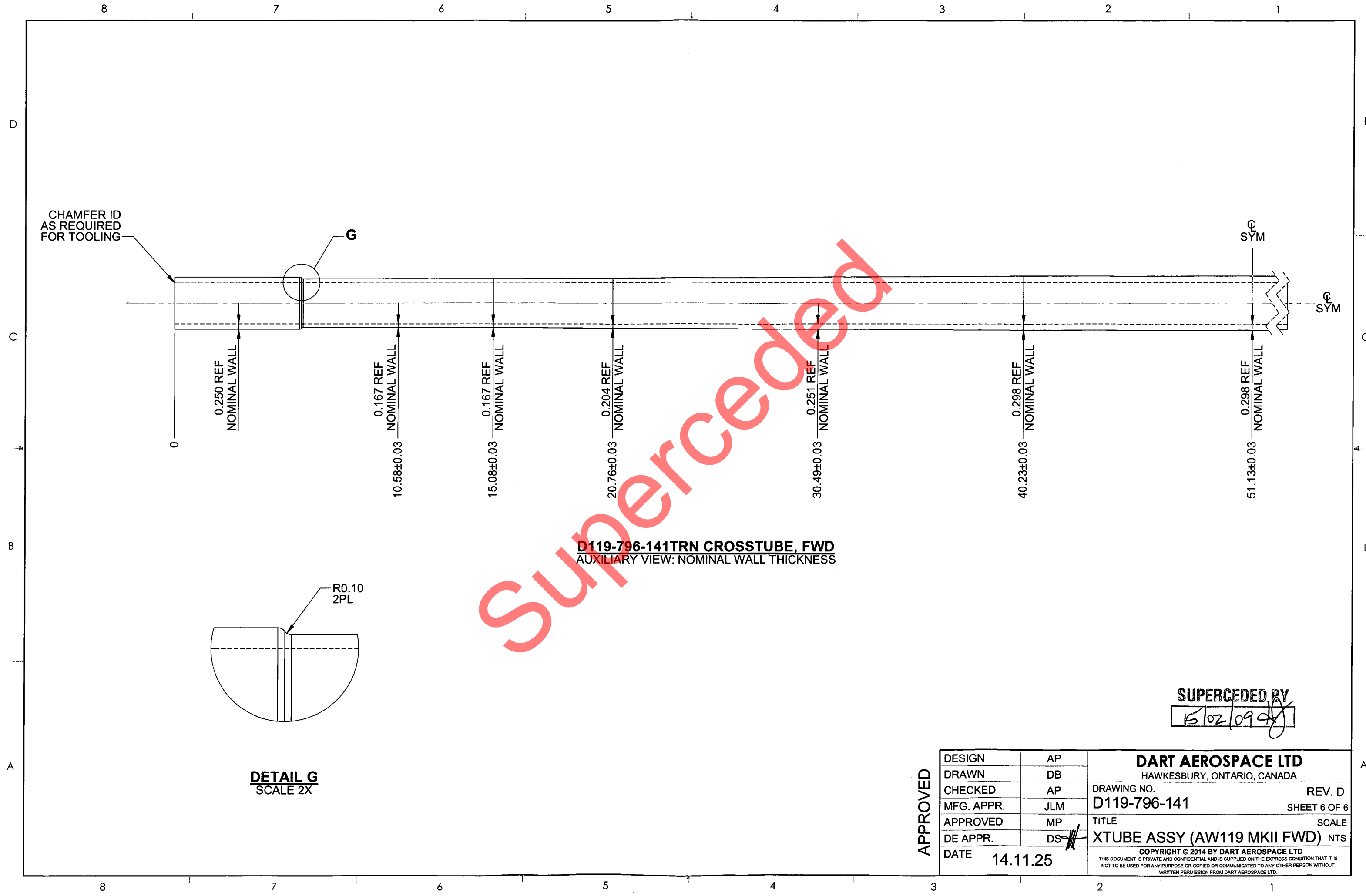
**D119-796-141TRN CROSSTUBE, FWD**

- NOTES:**
- 1) MATERIAL: MANUFACTURE FROM D6005-103  
FINISHED LENGTH = 102.26 ±0.020 (BEFORE BENDING/TRIMMING)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 16.70 lbs
  - 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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MFG. APPR.	JLM		SHEET 5 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>XTUBE ASSY (AW119 MKII FWD)</b>	NTS
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15/02/09



CHAMFER ID  
AS REQUIRED  
FOR TOOLING

0.250 REF  
NOMINAL WALL

0.167 REF  
NOMINAL WALL

0.167 REF  
NOMINAL WALL

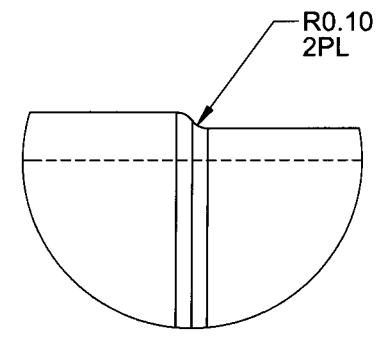
0.204 REF  
NOMINAL WALL

0.251 REF  
NOMINAL WALL

0.298 REF  
NOMINAL WALL

0.298 REF  
NOMINAL WALL

**D119-796-141TRN CROSSTUBE, FWD**  
AUXILIARY VIEW: NOMINAL WALL THICKNESS



**DETAIL G**  
SCALE 2X

**SUPERCEDED BY**  
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MFG. APPR.	JLM	<b>D119-796-141</b>	SHEET 6 OF 6
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